

Work Order ID 127166

Wednesday, December 10, 2014 8:03:50 AM

127166

Page 1

Item ID: D4018-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Short Basket Lid Assembly (350)
 Start Date: 12/10/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/10/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 12-10-10 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4018	D								
100	Weld per dwg A/R S.S. rod Batch: <u>M130267</u>	0.00							
100	Large Fab								
	Memo	0.00							
	1- assemble ribs, weld as per dwg D4018 using DT9607B								
	2- weld hinge (3) and Mounting brackets as per dwg D4018								
	inspect before welding mesh								
	3- tack weld mesh on basket as per dwg D4018								
	make sure to place mesh correctly on lid, check with label plate before tacking mesh								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110	QC								
	Memo	0.00							
	Quality Control								

1x **DAS**
43
9-89 **DEC 10 2014**

DAS
24
9-89 **DEC 24 2014**

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Item ID: D4018-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00				1		DEC 24 2014	DAS 24 9-89
120									
QC	Memo	0.00							
Quality Control									
130	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	*** mask sides of hinge prior to powdercoat*** Start Time: 8:25 Oven Temperature: 320 Finish Time: 8:55								
140	Wing Walk as per dwg QSI005 4.4 Batch 11130900	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing	1- Mask data plate and apply wing walk on outside surface of mesh as per dwg Install placard and label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***								

1 Ø 15-1-7. DAS 34 9-89
 14 of 40 12/01/09

PTO
 →
 see NCR15-4524

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Item ID: D4018-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Short Basket Lid Assembly (350)
Start Date: 12/10/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/10/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00				①	15-01-26		DAS 9 9-89
Quality Control									

160	Identify as per dwg & Stock Location: <u>w/o</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									

04032-041/13125503

170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

15/2/17

2-13

Picklist Print

Wednesday, December 10, 2014 8:04:48 AM

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Work Order ID: 127166

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Parent Item: D4018-041

D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 12/10/2014

Required Date: 12/10/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as
per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg
RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD
10.08.18 verified by:EC IPP REV:E 13.08.21 DWG REV.D / ECN 13-
624 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4018-1 *D4018-1* Rib		Manufactured	No			100	Each	6.0000	2	2	DAS 43 9-89	DEC 10 2014	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		6							
				121816		6							
D4018-3 *D4018-3* Rib		Manufactured	No			100	Each	6.0000	2	2	DAS 43 9-89	DEC 10 2014	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		6							
				121887		6							
D4016-3 *D4016-3* Hinge Half, Lid		Manufactured	No			100	Each	19.0000	3	3	DAS 43 9-89	DEC 10 2014	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		19							
				115144		4							
				117504		1							
				122352		1							
				122694		4							
				124432		9							

Picklist Print

Wednesday, December 10, 2014 8:04:48 AM

Page 2

Work Order ID: 127166

127166

Parent Item: D4018-041

D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 12/10/2014

Required Date: 12/10/2014

Start Qty: 1.00

Required Qty: 1.00

D4018-5 Manufactured No

100 Each 48.0000 6 6

D4018-5

Rib

**

DAS
43
9-89

DEC 10 2014

Location	Loc Qty	Loc Code
WA004	48	
110936	9	
116882	9	
116884	30	

B 116884 → 6x

D4035-043 Manufactured No

100 Each 8.0000 2 2

D4035-043

Lid Rib Assembly, Aft (350 Basket)

**

DAS
43
9-89

DEC 10 2014

Location	Loc Qty	Loc Code
WA004	8	
115935	2	
122271	2	
127022	4	

B 127022 → 2x

D2581 Manufactured No

100 Each 108.0000 2 2

D2581

Mounting Bracket

**

DAS
43
9-89

DEC 10 2014

Location	Loc Qty	Loc Code
WA004	108	
102265	60	
117900	2	
122730	46	

B 122730 → 2x

D4020-7 Manufactured No

100 Each 1.0000 1 1

D4020-7

Mesh (350 Basket Short, Lid)

**

DAS
43
9-89

DEC 10 2014

Location	Loc Qty	Loc Code
WA006	1	
116916	1	

B 116916 → 1x

Picklist Print

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Work Order ID: 127166

127166

Parent Item: D4018-041

D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 12/10/2014

Required Date: 12/10/2014

Start Qty: 1.00

Required Qty: 1.00

D4021-3

Manufactured No

100

Each

14.0000

1

1

DAS

43

9-89

DEC 10 2014

D4021-3

Data Plate

**

B125835 → 1x

Location

Loc Qty

Loc Code

WA004

14

116081

1

125833

13

D2728-3

Manufactured Yes

140

Each

0.0000

0

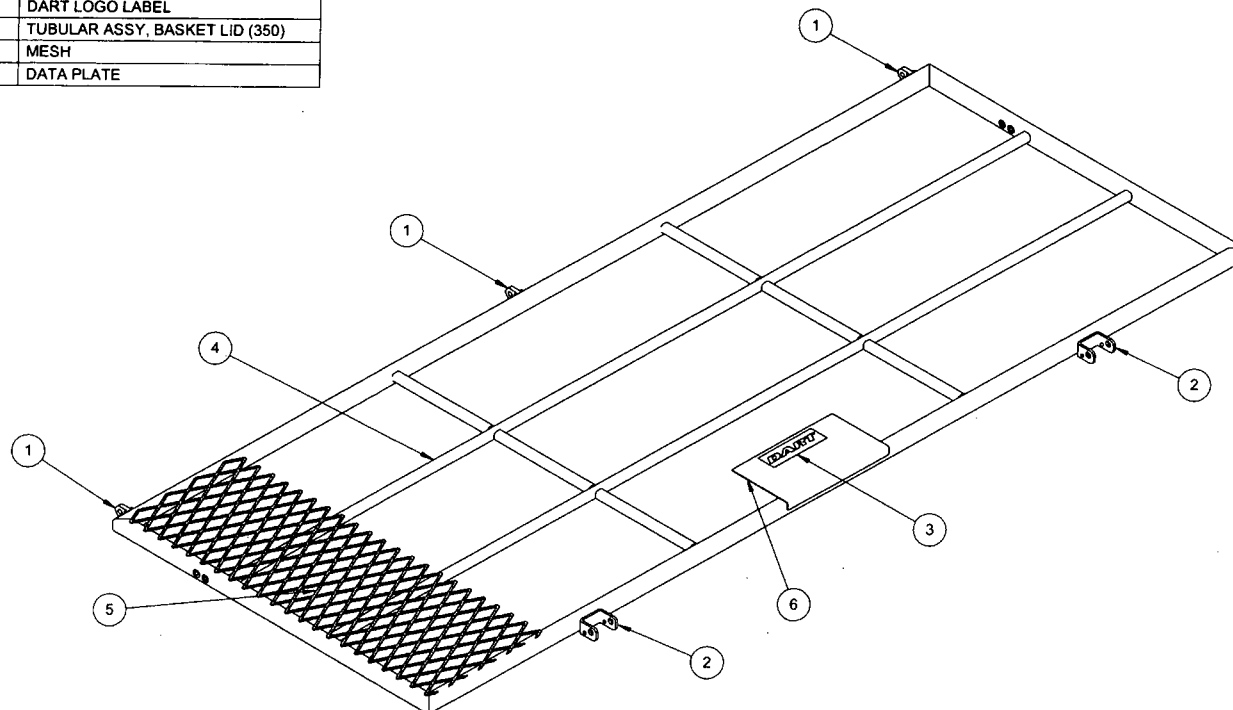
D2728-3

Dart Logo Label Large

**

9
Jll 12/10/14

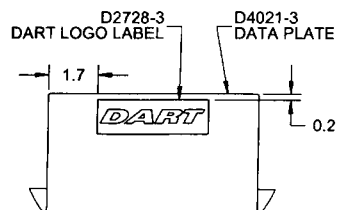
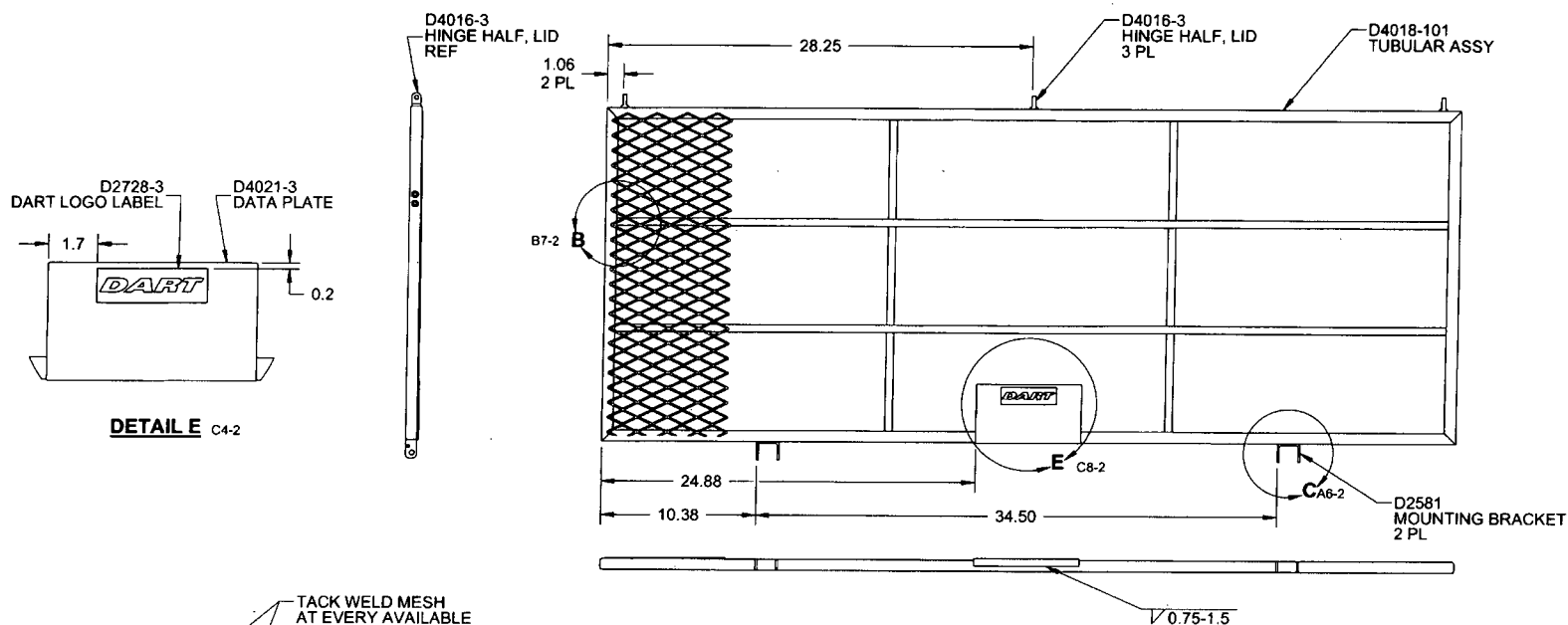
ITEM	QTY -041	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D4016-3	HINGE HALF, LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE



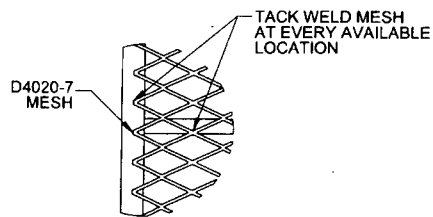
D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2013-08-16

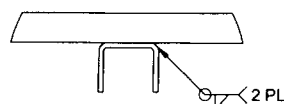
D	C7-3 D4035-043 WAS D4035-041 (REASON: PROPARM OPTION DELETED).	AJS	13.07.18
C	REMOVED D4086-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4086-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.		D4018	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET LID ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



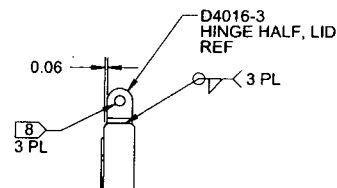
DETAIL E C4-2



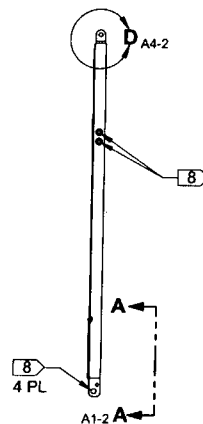
DETAIL B C6-2



DETAIL C C3-2



DETAIL D D1-2



VIEW A-A C1-2

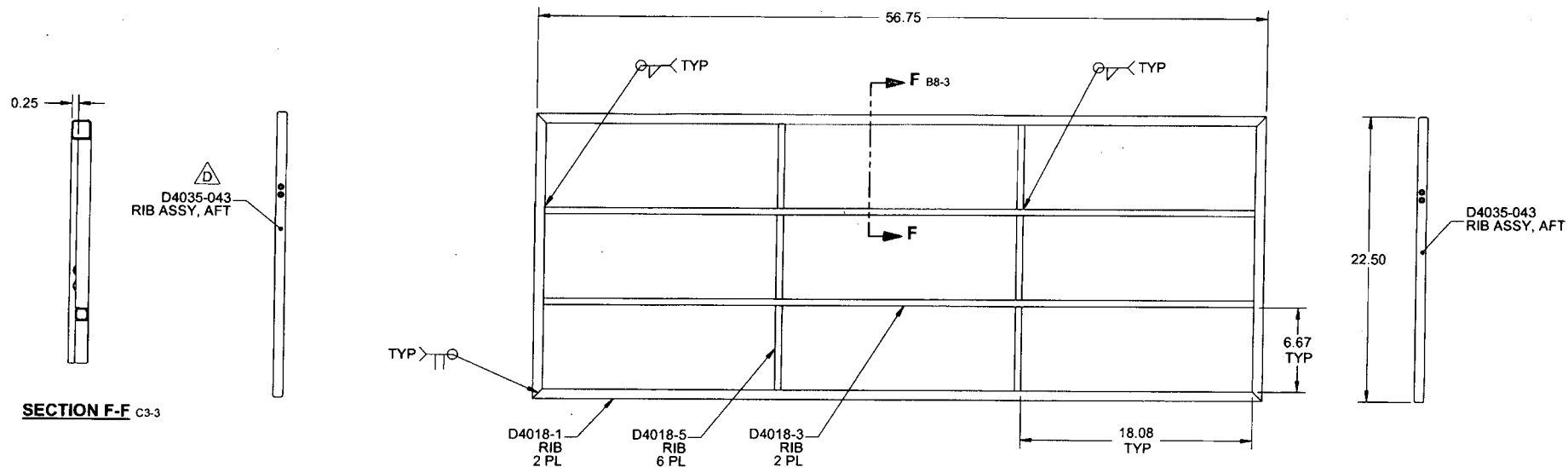
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.5 lbs APPROX
 - 8) MASK HOLES PRIOR TO FINISHING
 - 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED	<i>[Signature]</i>	DRAWING NO. D4018 REV. D
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE SHORT BASKET LID ASSY (350) SCALE NTS
DE APPR.	<i>[Signature]</i>	
DATE	13.07.18	

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RELEASED
2013-08-16

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	2	D4035-043	BASKET LID RIB ASSY, AFT



SECTION F-F C3-3

8 D4018-101 TUBULAR ASSY, BASKET LID (350)

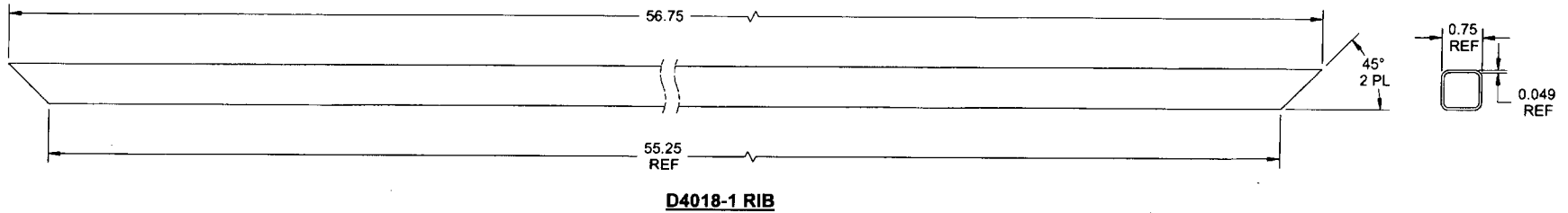
RELEASED
2013-08-16

NOTES:

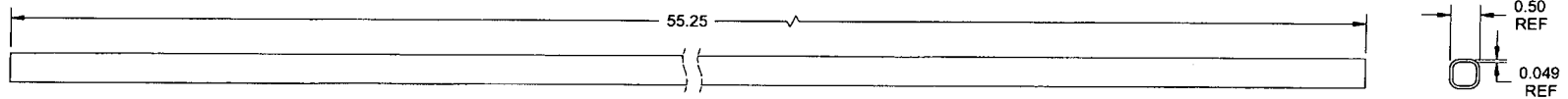
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.06 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4018	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET LID ASSY (350)	NTS
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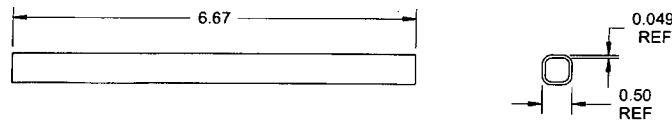
8 7 6 5 4 3 2 1



D4018-1 RIB



D4018-3 RIB



D4018-5 RIB

NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
2013-08-16
AA

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4018	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SHORT BASKET LID ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1



Non-Conformance Report

Reviewed	
DQA:	
Date:	

Printed on: Thursday, January 08, 2015

Details			
Raised Date 1/7/2015	Status Open	Owner Forbes, Nigel	Number NCR15-4524
Target Date 1/23/2015	Standard	Severity MAJOR	
Process Inspection		Audit	
Raised By Person Duval, Patrick	Raised Against (Department or Supplier) Manufacturing\Large Fab	Fault Category General\Positioned Wrong	
Details During assembly of D350-607-545 B125499, employee found that D2581 on the basket lid D4018-041 & basket base D4017-041 were not position correctly.			
Keywords wrong location		Product	
Document		Root Cause Lack of Attention	
Closed By	Closed Date	Resolution Rework	

Corrective Action			
Target Date 1/23/2015	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
1	Provencal, Chris	1/20/2015	
get approval as per QSI 042 to rework NC		CP 15/1/8	
2	Laviolette, Carl	1/20/2015	
-removed and replace non conformant D2581 on basket lid & basket base.-weld D2581 B 122730 on basket lid & basket base as per dwg A/R S.S. rod M. 125054		CC 15-1-8	
3	Duval, Patrick	1/20/2015	
-QC9 inspect weld has per QSI004-QC5 inspect measurements as per dwg 10.38" and 34.50" & record all dims on NCR		DAS 9 34.50" + 10.38 15-01-08	

4	Lacelle, Linda	1/20/2015	
Scuff all aeras with 320 grit sand paper clean to ensure that all basket is cleaned powder coat as per QSi 005 START <u>10.5</u>		<u>M. 127892</u>	
TEMP <u>410</u>	FIN <u>10.5</u>	TEMP <u>15-1-12</u>	<u>888</u>

Verification & Review

Target Date 1/23/2015	Owner Smith, Patrick	Closed Date	Closed By
Details			

Actions

Number	Owner	Target Date	Completed Date
Details		Response	

BASKET LID BLACK SANDIEX RECOAT.

M 127892

START: 8:00

1 of 15-1-9. 888

OPEN: T. 320°

FINISH: 9:30.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
--	---	--	---	--	--	--

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design		15/1/8		1	LID NOT ALIGNING. Reb NCR 15-4524	DAS 12 9-89 15/1/8	Acceptable to REMOVE HINGE tabs and re-install. Re-powder coat per QSI 005	11/14/5/09 15-9- DAS 34 9-89	DAS 15 9-89	150109 DAS 9 9-89
Doc/Data										
Equip/Tooling										
Handling/Pre										
Material										
Operator										
Offset/Setup										
Process										
Supplier										
Training										
Transport										
Unapproved										

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--	--